



Dart Aerospace Ltd.
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D4667-041
Job Sheet 176246



Part No: D4667-041

Job Qty: 12 ea

Part Name: Armrest Stud Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/19/18

Job Tracking No:

Due Date: 5/2/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV A IPP REV:A 12/06/11 as per dwg rev.PA1 JFS ver: DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea		5/2/18	0.00	0.00	Start Up Machining-3		JB-18-04-26
100	Hardinge	12 pcs		5/2/18	0.00	5.45	Hardinge		JB-18-04-26
110	QC	12 pcs		5/2/18	0.00	0.00	QC2 Machining-3		JB-18-04-26
120	QC	12 pcs		5/2/18	0.00	0.00	QC8 Machining-3		JB-18-04-26
130	Small Fab	12 pcs		5/2/18	0.00	0.81	Small Fab-7		JB-18-04-26
140	QC	12 pcs		5/2/18	0.00	0.00	QC5		DAS 38
150	Packaging	12 pcs		5/2/18	0.00	0.00	Packaging3-2		9-89
160	QC21-SA	12 Ea		5/2/18	0.00	0.00	QC21		DAS 21 MAY 14 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M4130NR0.750	4130 Steel Round Bar .750"	1.4400 ft (.12 ea)	90-Start up Operation	
MS21209-F415	Heli-Coil	12 Ea (1 ea)	130-Small Fab	F4137951.84

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M4130NR0.750	1	11	0
130-Small Fab	MS21209-F415	12	23	0

Part Specifications

Specifications could not be found.

176246

INSPECTION SHEET

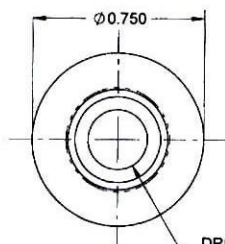
[illegible]

Measured by: JB. JPM	Checked by: [Signature]	QC Inspector:
Date: 18.04.26	Date: 18/04/28	Date:

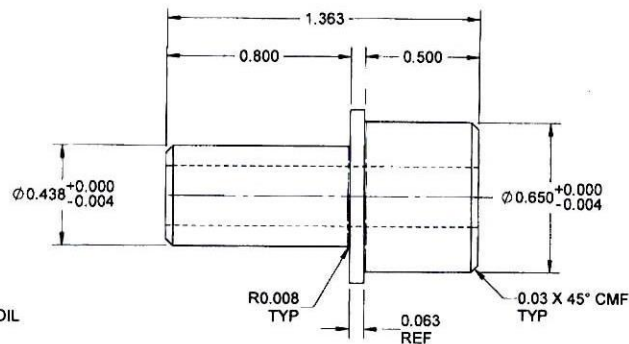
Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised By	Approved
A	15.02.03	New Issue	KJ	

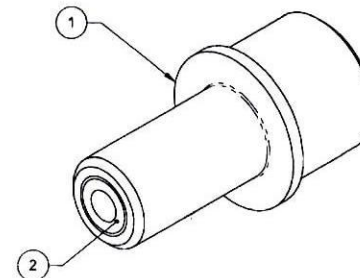
ITEM	QTY	P/N	DESCRIPTION
	X	D4667-041	ARMREST STUD ASSEMBLY
1	1	D4667-1	ARMREST STUD
2	1	MS21209-F415	HELICOIL, LOCKING



DRILL THRU $\phi 0.261$
TAP FOR 0.250-28 HELICOIL
0.45 DP



D4667-1 ARMREST STUD



D4667-041 ARMREST STUD ASSY

NOTES:

- 1) MATERIAL -041: N/A
-1: AISI 4130N ROUND BAR
PER MIL-S-6758 OR AMS 6348/6370/6528
REF M4130N-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.07 lbs

RELEASE
2012-07-09

APR 12 2012

A	NEW ISSUE	AJS	12.06.12
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	TS	DRAWING NO.	REV. A
MFG. APPR.	TS	D4667	SHEET 1 OF 1
APPROVED	TS	TITLE	SCALE
DE APPR.	TS	ARMREST STUD ASSEMBLY	NTS
DATE	12.06.12	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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Container No: S065443



Part: D4667-041

Job No: 176246

Serial No/Batch: S065443

Revision:

Inspector:

Date: 04/26/18